

Date: Monday, 7/9/2007 11:53:32 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	DRIVESHAFT TUNNEL MOD KIT
Job Number	33402			
Estimate Number	12544			
P.O. Number	N/A		Part Number	D412705015
This Issue	7/9/2007	S.O. No. : N/A	Drawing Number	IIN D412-705 PG 14
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type : SMALL /MED FAB	Drawing Revision	B
Previous Run	30125		Material	N/A
Written By			Due Date	8/10/2007
Checked & Approved By		7/9/07.09	Qty:	4
Comment	Est Rev:B	Removed Manufacturing 06-10-03 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	KJ 07.07.30
		Comment: Photocopy bluefile & type labels per PPP D412-705-015	CHG002
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	EN 07/09/13
3.0	D3256041	Access Panel Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	0 7/8/17
		Access Panel Assembly	1/9/13 SP
		Batch: 33475	
4.0	AN3C3A	Bolt	
		Comment: Qty.: 22.0000 Each(s)/Unit Total : 88.0000 Each(s)	EP
		Bolt	17102339182 M103668 (CX) -
5.0	AN3C4A	BOLT	
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)	EP
		BOLT	M105143 -
6.0	MS932109	Washer	
		Comment: Qty.: 25.0000 Each(s)/Unit Total : 100.0000 Each(s)	EP
		Washer	17108575 M102382 32x -
		Batch: 17108575 M102382 32x -	EP 07/08/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRIVESHAFT TUNNEL MOD KIT

Job Number: 33402

Part Number: D412705015

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 MS20427M33

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total: 176.0000 Each(s)

Rivet

Batch:

MS21060L3K

Nut Plate



Comment: Qty.: 22.0000 Each(s)/Unit Total: 88.0000 Each(s)

Nut Plate

Batch:

M18575-

9.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-705-015

Location:

PPP Rev:

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-705-011 Twin Pak E-Z Access Kits (net)	6.3 lb 2.86 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	189 in 4.80 m	1190.7 in lb 13.73 m kg
D412-705-013 Intake Plenum Access Panel Kit	2.5 lb 1.16 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	175 in 4.44 m	437.5 in lb 5.15 m kg
D412-705-015 Drive Shaft Tunnel Modification Kit	1.1 lb 0.50 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	189 in 4.81 m	208.2 in lb 2.41 m kg
D412-705-017 N1 Gearbox Access Panel Kit (net)	1.0 lb 0.47 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	166 in 4.22 m	166.0 in lb 1.98 m kg
D412-705-019 C-Box Oil Cooler Line Support Access Kit (net)	1.2 lb 0.53 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	238 in 6.05 m	278.5 in lb 3.21 m kg
D412-705-021 Oil Pressure Transmitter Access Kit (net)	0.3 lb 0.14 kg	-6.0 in -0.15 m	-1.8 in lb -0.02 m kg	166 in 4.22 m	49.8 in lb 0.60 m kg
D412-705-023 Oil Cooler Support Removable Lower Panel Kit (net)	0.2 lb 0.09 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	238 in 6.05 m	47.6 in lb 0.55 m kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
1							D3245-041	ACCESS PANEL ASSEMBLY, LH
1							D3245-042	ACCESS PANEL ASSEMBLY, RH
2							D3245-043	DOOR ASSEMBLY
		1					D3255-041	ACCESS PANEL ASSEMBLY, LH
		1					D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-041	ACCESS PANEL ASSEMBLY
			1				D3259-041	ACCESS PANEL ASSEMBLY, LH
			1				D3259-042	ACCESS PANEL ASSEMBLY, RH
				1			D3307-041	ACCESS PANEL ASSEMBLY
					30		AN3-3A	BOLT
	22	30		6			AN3C-3A	BOLT
	3						AN3C-4A	BOLT
					30		AN960JD10	WASHER
	44	36		12			MS20427M3-3	RIVET
					2		MS21051-L3K	NUT PLATE
	22	18		6			MS21060-L3K	NUT PLATE
					18		MS21069-L3K	NUT PLATE
	25	30		6			MS9321-09	WASHER

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER